

# Work Order ID 84474

**\*84474\***

Page 1

May-15-12 1:00:47 PM

Item ID: D206-642-411

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH

Start Date: 5/14/12 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00

**\*1\***

Customer:

Reference: rework - ECN09-531

Approvals: Process Plan: *W* Date: Tooling: Date:

Run Start **\*NR1\***

QC: Date: SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D206-642	O

100

**\*100\***

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D206-642-411 CHG006

0.00

0.00

*Sizla*

*for mls 12-6-17*

<b>DART</b>		TEL: 1-613-632-3336	
TRANSPORT CANADA APPROVAL # 09-89		FAX: 1-613-632-4143	
P/N	D206-642-411	CHG	CHG004
DESC	Skidtube LH High	SIC	SH98-4
LOT	B38778	SIC	SA00475SE
MODEL	Bell 206L/L1/L3/L4	SIC	
US PATENT # 6735484		MADE IN CANADA	
CANADA FOREIGN PATENTS PENDING			

# Work Order ID 84474

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**\*84474\***

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Item ID: D206-642-411

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Skidtube LH

Stop **\*NS2\***

Start Date: 5/14/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/14/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference: rework - ECN09-531

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
101		0.00							
<b>*101*</b>									
HandFinish	Memo	0.00							
Hand Finishing	PULL FROM HK: 1 X D206-642-411 B38778 UPDATE TO CHG006 PER ECN08-538 & 09-531 DSI9421/9440  REMOVE WEARPLATES: 6 X D2648-3 B34591 1 X D2656-15 B34596 1 X D2656-23 B34597 1 X D2656-37 B34510 1 X D3429-1 B34609 RETURN TO STK DISCARD HARDWARE  ADD: 6 X D3537-1 B <u>841091</u> 1 X D3537-3 B <u>81363</u> 1 X D3535-15 B <u>81354</u> 1 X D3536-15 B <u>32310</u> 1 X D3535-23 B <u>33215</u> 1 X D3536-23 B <u>33339</u> 1 X D3536-37 B <u>66823</u> 1 X D3536-37 B <u>11126302</u> 60 X MS27039C1-08 B _____ 60 X AN960C10L (NAS1149C0332R) B <u>11121569</u>								

ix d Hl 12/06/00

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Setup Start \*NS1\*

Revision ID:

**Item Name:** Skidtube LH

Stop \*NS2\*

\* 1 \*

**Cust Item ID:**

**\* 1 \***

**Customer:**

**Reference:** rework - ECN09-531

Run Start \*NR1\*

Stop \*NR2\*

**Insp.  
Stamp**

105

QC5- Inspect part completeness to step on W/O

0.00

**\*105\***

QC

## Memo

0.00

## Quality Control

51766605

# Work Order ID 84474

**\*84474\***

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May-15-12 1:00:47 PM

Item ID: D206-642-411 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Skidtube LH  
 Start Date: 5/14/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 5/14/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference: rework - ECN09-531

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Pick Kit	0.00							
<b>*110*</b>									
Packaging									
Packaging									
	Memo	0.00							
	REMOVE FROM KIT TO UPDATE TO CHG006:								
	1 X D2707-043(OR D2968-043)-SCRAP	37380							
	1 X AN960JD1016 B	SS19							
	1 X AN970-4 B	107242							
	1 X MS210424 B	106051							
	1 X AN4-5A B	106605							
	1 X AN960JD416 B	107321							
	1 X D2655 B	34613							
	RETURN TO STK								
	ADD TO KIT:								
	1 X D3407-043 B								
	1 X D3456-1 B	81826							
	2 X D3457-1 B	81927							
	1 X MS21043-4 B	121162							
	1 X AN4C5A B	119017							
	1 X AN960C416 B	119097							
	1 X D3413-1 B	85307							

NAS1149C0463R

2/6/78



# Picklist Print

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Page 1

Work Order ID: 84474

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:K05.10.11Revised picklist per CHG004KJ/CP/JLM  
IPP Rev:L 07-12-04 ECN 1080p DD verified by:ec  
IPP rev:M 08-09-29 as per DS19421 DD verified by:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-5A Bolt		Purchased	No				Each	974.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		974							
				120562		974							
AN4C5A BOLT		Purchased	No				Each	199.0000		1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST355		199							
				112243		139							
				119017		60							
AN960C416 washer	NAS1149C0463R	Purchased	No				Each	0.0000		1			
AN960JD1016 Washer	NAS1149C1063R	Purchased	No				Each	369.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				Mezz		369							
				5519		369							
AN960JD416 Washer	NAS1149D0463J	Purchased	No				Each	30.0000		-1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST351		30							
				116289		10							
				119097		20							

D2968.043

B37380

# Picklist Print

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Work Order ID: 84474

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

AN970-4 Washer	Purchased	No	Each	203.0000	-1	M1072428
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
			ST344	203		
			115936	11		
			120308	3		
			120644	30		
			121285	159		
D206-642-411 Skidtube LH	Manufactured	No	Each	1.0000		M1106101
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
			FG081	1	B38778	X1
			78486	1		
D2648-3 Wearpad	Manufactured	No	Each	9.0000		M-6 1106101
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
			ST	-10		
			81513	9	B34591	X6
			ST237A	19		
D2655 Ring	Manufactured	No	Each	30.0000	-1	B346130
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
			ST464	30		
			44295	15		
			45738	15		
D2656-15 Wearshoe	Manufactured	No	Each	6.0000		M11106101
			<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
			FP	5	B34596	X1
			83601	5		
			Mezz	1		
			51455	1		

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Shop Packet Print

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# Picklist Print

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Work Order ID: 84474

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D2656-23 Manufactured No Each 9.0000  
Wearshoe

M<sup>1</sup> 121061001

Location	Loc Qty	Loc Code
Mezz	9	B 34597
43407	2	
51468	7	

VI

D2656-37 Manufactured No Each 21.0000  
Wearshoe

M<sup>1</sup> 121061001

Location	Loc Qty	Loc Code
Mezz	21	
34510	2	
44550	7	
46497	1	
53019	11	

VI

D3407-043 Manufactured No Each 14.0000  
Tow Ring

B 83325 s...

Location	Loc Qty	Loc Code
ST420	1	
79232	1	
ST463	13	
68339	2	
77504	10	
78841	1	

D3413-1 Manufactured No Each 73.0000  
Ring

1 121061001

Location	Loc Qty	Loc Code
ST420	4	
79233	4	
ST464	69	
76754	1	
80224	7	
83307	41	
83867	20	

1

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# Picklist Print

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Work Order ID: 84474

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3429-1  
Wearpad

Manufactured No

Each 16.0000

bl -1 11/06/04

Location

Loc Qty

Loc Code

FP002

16

B341609

40438

2

43706

1

44579

12

65692

1

Y1

D3456-1  
Washer

Manufactured No

Each 168.0000

1

Location

Loc Qty

Loc Code

FG

7

25701

7

ST044

161

80252

1

81876

60

83584

100

1

D3457-1  
Washer

Manufactured No

Each 35.0000

2

12/06/07

Location

Loc Qty

Loc Code

FG

10

32409

10

ST044

25

67779

1

81977

24

2

D3535-15  
Wearshoe

Manufactured No

Each 17.0000

Y1

bl 1 12/06/04

Location

Loc Qty

Loc Code

FP001

17

80328

4

81354

13

Y1

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Shop Packet Print

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# Picklist Print

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Work Order ID: 84474

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3535-23 Manufactured No Each 22.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP001	22	
81355	2	
83375	20	

22<sup>1</sup> 12/06/04  
VI

D3535-37 Manufactured No Each 4.0000  
Wearshoe

Location	Loc Qty	Loc Code
FP001	4	
71668	4	1384827

4<sup>1</sup> 12/06/04  
VI

D3536-15 Manufactured No Each 20.0000  
Gasket

Location	Loc Qty	Loc Code
FP002	20	
73318	14	
81343	6	

20<sup>1</sup> 12/06/04  
VI

D3536-23 Manufactured No Each 16.0000  
Gasket

Location	Loc Qty	Loc Code
FP002	16	
74510	1	
83377	15	

16<sup>1</sup> 12/06/04  
VI

D3536-37 Manufactured No Each 19.0000  
Gasket

Location	Loc Qty	Loc Code
FP002	19	
66823	7	
82623	12	

19<sup>1</sup> 12/06/04  
VI

# Picklist Print

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Work Order ID: 84474  
Parent Item: D206-642-411  
Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

D3537-1 Manufactured No Each 41.0000  
Wearpad

Location Loc Qty Loc Code

FG	10	B84091
79833	10	
FP002	31	
69817	5	
81362	22	
83254	1	
83255	3	

21 11/06/12

x6

D3537-3 Manufactured No Each 28.0000  
Wearpad

Location Loc Qty Loc Code

FP002	28
78836	5
<u>81363</u>	23

21 11/06/12

X1

MS21042-4 Purchased No Each 1,071.0000  
USE MS21042L4

Location Loc Qty Loc Code

ST299	1071
100743	9
119124	1000
5461	1
6844	19
7690	24
8182	6
9063	8
9229	4

21 11/06/12  
M106051

May-15-12 1:00:46 PM

Shop Packet Print

Page 6

# Picklist Print

May-15-12 1:00:46 PM

Page 7

Work Order ID: 84474

Parent Item: D206-642-411

Parent Item Name: Skidtube LH

Start Date: 5/14/12

Required Date: 5/14/12

Start Qty: 1.00

Required Qty: 1.00

MS21043-4 Purchased No Each 1,546.0000  
Nut

1 *SD* *12/6/17*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	40	
104603	40	
ST301	1506	
119546	185	
<u>121162</u>	821	
121652	500	

*1* *✓* *✓*

MS27039C1-08 Purchased No Each 1,142.0000  
SCREW

*60* *12/06/10*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	1	
116022	1	
ST292	1122	
<u>120308</u>	354	
121068	108	
121162	660	
ST293	19	
116373	3	
118077	14	
119309	2	

*x60*

NAS1149C0332R Purchased No Each 3,354.0000  
Washer

*60* *12/06/10*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	219	
119736	196	
120648	23	
ST298	3135	
121255	11	
<u>121509</u>	3124	

*x60*

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Shop Packet Print

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Date: Thursday, 24/04/2008 3:29:39 PM  
User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE  
Job Number : 38778A  
Estimate Number : 10522  
P.O. Number : Part Number : D206642441  
This Issue : 24/04/2008 S.O. No. : Drawing Number : D2650 REV E  
Prsht Rev. : NC Project Number : N/A  
First Issue : 11 Type : LANDING GEAR Drawing Revision : E  
Previous Run : 38777A Material :  
Written By : Due Date : 05/05/2008 Qty: 1 Um: Each  
Checked & Approved By : SLD 08.4.24  
Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM

Additional Product

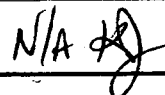
Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL



 

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A 

2.0	D2620	Skidtube, 206 Skidtube
-----	-------	------------------------



 

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2620	Bent Tube 3" OD	32449 SL 8-4-29

3.0	D2647	Cap
-----	-------	-----



 

Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2647	Fwd Cap	35475 BE 08-04-30

4.0	SKIDTUBES 1	SKIDTUBESS.RESOURCE 1
-----	-------------	-----------------------

Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod M106330 / M107263 BE 08-04-30

4-Grind weld flush to cap on top surface only. SL 8-5-1

SL 8-4-29

Date: Thursday, 24/04/2008 3:29:39 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 38778A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

SL 8-5-1

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 8-5-1

6.0

D26547

Web



Comment: Qty.: 1.0030 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number  
1 D2654-7

Description  
Web

Batch

35994

SL 8-5-1

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 8-5-1 Time: 10:45

Finish Date: 8-5-20 Time: 10:00 AM

A/R Sikaflex-291 107804

Sikaflex expiry date: 8-7-31

SL 8-5-1

Date: Thursday, 24/04/2008 3:29:39 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 38778A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/06

9.0

D2649

Cross Bolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

B37859 BE 08/05/06

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

m107877 BE 08/05/06

2-Grind weld's flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

72 8-5-7

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650Debur

11.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2680-041

Nut Plate

34599 SL 8-5-7

12.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 CCR264SS3-3

Rivets

107107 SL 8-5-7

Date: Thursday, 24/04/2008 3:29:39 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 38778A

Part Number: D206642441

Job Number:



30 mm

09/05/2008

S.230

09.17

#1

322.4

#2

D206642441

#3

B38778A

#4

Seq. #:	Machine Or Operation:	Description :
13.0	M7885343	Rivet
Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 M7885/3-4-3 Rivets 102513 SL 8-5-7		
14.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Install D2680-041 Nut Plate as per Dwg D2650 SL 8-5-7		
15.0	QC10	VISUAL INSPECTION OF GROUND WELDS
Comment: VISUAL INSPECTION OF GROUND WELDS S 08/05/09		
16.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP S 08/05/09		
17.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Pressure wash as per QSI 005 M/A 08/05/09 (IX)		
18.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING Powder Coat White (Ref. 4.3.5.1) as per QSI 005 4.3 Make sure Nut Plate Thread protected use paint screw FL 08/05/09 (IX)		
19.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION M/A 08/05/12 (IX)		
20.0	D26483	Wearpad
Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s) Pick: Qty Part Number Description Batch 6 D2648-3 Wearpad B 34591 M/A 08/05/12 (IX)		



Date: Thursday, 24/04/2008 3:29:39 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 38778A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D265615

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe

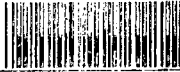
B34596

M-L

22.0

D265623

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe

B34597

M-L

23.0

D265637

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe

B34510

M-L

24.0

D34291

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad

B34609

M-L

25.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total: 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts

or (see QSI 017)

M105819

M-L

M-L 08/05/12

Date: Thursday, 24/04/2008 3:29:39 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 38778A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description:

26.0

AN960JD10L

Washer



Comment: Qty.: 62.0000 Each(s)/Unit Total: 62.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 AN960JD10L

Washer

M104885

M-h

27.0

MS27039108

Screw



Comment: Qty.: 62.0000 Each(s)/Unit Total: 62.0000 Each(s)

Pick:

Qty Part Number

Description Batch

62 MS27039-1-08

Screw

M107378

M-h

28.0

D26511

Plug



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-1

Plugs

B38273

M-h

29.0

D26513

O-Ring



Comment: Qty.: 22.0000 Each(s)/Unit Total: 22.0000 Each(s)

Pick:

Qty Part Number

Description Batch

22 D2651-3

O-Rings

B36141

M-h

30.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 AN960JD416

Washer

M105426

M-h 08/05/12

(1X)

Date: Thursday, 24/04/2008 3:29:39 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 38778A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

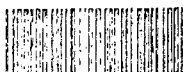
M106541

M-L

32.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2646

Aft Cap

B36184

M-L

33.0

HAND FINISHING I

HAND FINISHING RESOURCE #1



(X)

Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

Sikaflex expiry date

M107804

08/10

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

Sikaflex expiry date:

M107804

08/10

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch:

M107380

M-L

08/05/12

34.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/13

Date: Thursday, 24/04/2008 3:29:19 PM  
User: Julie Lecocq

# Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	206L/L3/L4 HIGH GEAR SKID
<b>Job Number</b> :	38778		
<b>Estimate Number</b> :	10525		
<b>P.O. Number</b> :		<b>Part Number</b> :	D206642411
<b>This Issue</b> :	24/04/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	N/A
<b>First Issue</b> :	11	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	38777	<b>Drawing Revision</b> :	L
	<b>Type</b> :	<b>Material</b> :	
	LANDING GEAR	<b>Due Date</b> :	05/05/2008
<b>Written By</b> :		<b>Qty:</b>	1
<b>Checked &amp; Approved By</b> :	J20 08.4.24	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev:K 05.10.11 Revised picklist per CHG004 KJ/CP/JLM Est Rev:L 07-12-04 ECN 1080p DD verified by:		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-411 CHG004

J20 08.4.28

2.0	38778A	206 L HIGH GEAR SKIDTUBE
-----	--------	--------------------------



**Comment:** Sub-Component 206 L HIGH GEAR SKIDTUBE

D206-642-441 B 38778A

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D206648011	GHW Modification
-----	------------	------------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GHW Modification Kit

Batch: B36140

5.0	D2652	Bushing
-----	-------	---------



**Comment:** Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

16 D2652 Bushing 38815

1 D206-642-441(REF) 38778A

8/2/14 (1)

Date: Thursday, 24/04/2008 3:29:20 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 38778

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2655

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2655

Tow Ring

B34 613

7.0

D2712

Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

10 D2712

Set Screw

34628

8.0

D29321

Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2932-1

Saddle

36889

9.0

D29331

Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2933-1

Saddle

B39773

waya  
beta

AS 08/06/17

(X)

10.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2934

Saddle Spacer

37368

11.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 D2935

Saddle Spacer

37867

AS 08/06/17

Date: Thursday, 24/04/2008 3:29:20 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 38778

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D29381

Saddle LH Out, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2938-1

Saddle

34603

13.0

D29391

Saddle LH In, 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2939-1

Saddle

36143

14.0

D2968043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D2968-043

Tow Ring

1120 B 37350

15.0

AN341A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN3-41A

Bolt

M107242

16.0

AN45A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 AN4-5A

Bolt

M106095

8/01/14 D

Date: Thursday, 24/04/2008 3:29:20 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 38778

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

AN46A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

12 AN4-6A

Bolt

M106662

18.0

AN511A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN5-11A

Bolt

M105810

19.0

AN512A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

AN5-12A

Batch:

M104885

20.0

AN513A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch

M104936

21.0

AN960JD10

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

8 AN960JD10

Washer

M107715

22.0

AN960JD1016

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty Part Number

Description Batch

1 AN960JD1016

Washer

M10519

Date: Thursday, 24/04/2008 3:29:20 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L/L3/L4 HIGH GEAR SKID

Job Number: 38778

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN960JD416

Washer



Comment: Qty.: 25.0000 Each(s)/Unit Total : 25.0000 Each(s)

Qty Part Number

Description Batch

25 AN960JD416

Washer M107321

24.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty Part Number

Description Batch

8 AN960JD516

Washer M107534

25.0

AN9704

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty Part Number

Description Batch

1 AN970-4

Washer M107242

26.0

MS21042L3

Nut



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty Part Number

Description Batch

8 MS21042L3

Nut (or -3) M107647

27.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Qty Part Number

Description Batch

13 MS21042L4

Nut (or -4) M106051

28.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

506/04/19



Date: Thursday, 24/04/2008 3:29:20 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L/L3/L4 HIGH GEAR SKID

Job Number: 38778

Part Number: D206642411

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

PACKAGING 1

PACKAGING RESOURCE #1



1x

Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-642-411

Location:

PPP Rev: D

JS 08/06/18

(X)

30.0

QC21

FINAL INSPECTION/W/O RELEASE



08/06/19

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



JS 08-06-18

38778A

Part Number D206-642-411  
Description 206 SKIDTUBE INSTALLATION

Chg.	Date	By	Relevant Documents
1	98.12.14	DS	MDL - D206-642 REV. I
2	99.04.28	DS	- MDL - D206-642 REV. J - ADDED SADDLE SPACERS PER DSI 9150 REV. A - D2655 TOW RING SHIPPED LOOSE RATHER THAN INSTALLED ON SKIDTUBE
3	00.03.14	DS	CHANGE TO D2968-043 TOW RING PER DSF 9181 REV. A
4	05.10.04	CP	Add D3429-1 MDL - D206-642 Rev O
005	08.10.07	19	DSI 9421 Rev. A, D2650 Rev. F (ECN 08-538)
006	09.02.19	19	DSI 9421 Rev. B, DSI 9440 Rev. A, D206-648 Rev. B, D3414 Rev. B (ECN 09-53)

✓ 84474 - 38778

✓ 84475 - 34556

✓ 84476 - 38777

✓ 84477 - 34560

**ENGINEERING CHANGE NOTICE**  
**DART AEROSPACE LTD**

Date: 09.02.18	Job No.: 00569	ADR Yes/No: N	ADR Date:	ECN #: 09- 531
Product No.: D206-642	Created By: AJS	Approved By: <i>[Signature]</i>		
Product Name: Skidbe Installation	Checked By: <i>[Signature]</i>	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	<i>JA 09/02/19</i>
Production Engineering Coord	Y	EC/DD	<i>JA 09/02/19</i>
Production Document Control	Y	JLD	<i>JLD 09.02.19</i>
Customer Technical Support			

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord			
QC Coordinator	Y	JM	<i>JA 09.02.19</i>
Marketing	Y	SW	<i>SW 09.03.11</i>
Customer Order Processing			

**Reason for Change:** DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

**Documents Affected:**  
DSI 9421 REV B  
DSI 9440 REV A  
D206-648 REV B  
D3414 Rev B

**PARTS MUST COMPLY** ☐ **PREVIOUS PARTS SATISFACTORY** ☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		<i>09.02.19</i>
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		<i>09.02.19</i>
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		<i>09.02.19</i>
10	Update Controlled PDF Files	Y	KJ		<i>09.02.19</i>
11	Update Master Document List (MDL)	Y	AJS	<i>Rev. U</i>	<i>09.02.19</i>
12	Update Document Record (DR)	Y	KJ		<i>09.02.19</i>
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	<i>SEE BELOW</i>	<i>09.02.19</i>
18	Create / Update PPP's	Y	KJ		<i>09.02.19</i>
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		<i>09.02.19</i>
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		<i>09.02.19</i>
22					
23					

**Description / Action:**  
Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)  
*-141/-241 @ CHG 004, -143/-243 @ CHG 002 (PER DSI 9440 Rev. A)*  
Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)  
*-341/-441 @ CHG 003, -443 @ CHG 001, 343 @ CHG 002 (PER DSI 9440 Rev. A)*  
Previous parts Disposition: Depelete existing stock of -111/-112/-211/-212/-213/-214 parts @ Change 004 repectively. DO NOT mix parts from change 004 and change 005  
  
Previous parts Disposition: Depelete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006  
*D206-648-011/-013 NOW AT CHG002 (D206-648 Rev. B)-DO NOT MIX PARTS*

ECN Verified & Complete: *[Signature]*

Date: *09/03/16*

**ENGINEERING CHANGE NOTICE**  
**DART AEROSPACE LTD**

Date: 09.02.18	Job No: 00569	ADR Yes/No: N	ADR Date:	ECN #: 09- 531
Product No.: D206-642	Created By: AJS	Approved By: <i>[Signature]</i>		
Product Name: Skidbte Installation	Checked By: <i>[Signature]</i>	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	LL	
Production Engineering Coord	Y	EC/DD	<i>11 09/02/19</i>
Production Document Control	Y	JLD	<i>09.02.19</i>
Customer Technical Support			

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord			
QC Coordinator	Y	JM	<i>09.02.19</i>
Marketing	Y	SW	
Customer Order Processing			

Reason for Change: DESIGN IMPROVEMENT CHANGE FROM CARBON STEEL TO STAINLESS STEEL

Documents Affected:  
DSI 9421 REV B  
DSI 9440 REV A  
D206-648 REV B  
D3414 Rev B

PARTS MUST COMPLY ☐

PREVIOUS PARTS SATISFACTORY ☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	Y	KJ		<i>09.02.19</i>
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	Y	KJ		<i>09.02.19</i>
9	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		<i>09.02.19</i>
10	Update Controlled PDF Files	Y	KJ		<i>09.02.19</i>
11	Update Master Document List (MDL)	Y	AJS	<i>Rev. U</i>	<i>09.02.19</i>
12	Update Document Record (DR)	Y	KJ		<i>09.02.19</i>
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	Y	KJ	SEE BELOW	<i>09.02.19</i>
18	Create / Update PPP's	Y	KJ		<i>09.02.19</i>
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	Y	KJ		<i>09.02.19</i>
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		<i>09.02.19</i>
22					
23					

Description / Action:  
Roll -111/-112/-211/-212/-213/-214 to Change number 005 (Per DSI 9421)  
-141/-241 @ CHG 004 -143/-243 @ CHG 002 (PER DSI 9440 Rev. A)  
Roll -311/-312/-411/-412 To Change number 006 (Per DSI 9421)  
-341/-441 @ CHG 003 -443 @ CHG 001 343 @ CHG 002 (PER DSI 9440 Rev. A)  
Previous parts Disposition: Depelete existing stock of -111/-112/-211/-212/-213/-214 parts @ Change 004 repectively. DO NOT mix parts from change 004 and change 005  
  
Previous parts Disposition: Depelete existing stock of -311/-312/-411/-412 parts @ Change 005 DO NOT mix parts from change 005 and change 006  
D206-648-011/-013 NOW AT CHG002 (D206-648 Rev. B)-DO NOT MIX PARTS  
  
*N/A*  
*JW 09.03.03*

ECN Verified & Complete: \_\_\_\_\_

Date: \_\_\_\_\_

4.4 206L/L-1/L-3/L-4 High Gear Skidtubes (D206-642)  
32.13 206L/L-1/L-3/L-4 High Gear Skidtubes (ICA-D206-642)

IS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-013	GROUND HANDLING KIT
30	1	1				D3407-043	TOW RING ASSEMBLY
32A	1	1				D3456-1	WASHER
32B	2	2				D3457-1	WASHER
33	1	1				MS21043-4	NUT
34	1	1				AN4C5A	BOLT
35	1	1				AN960C416	WASHER
36	1	1				D3413-1	RING
40					2	D3414-041	LUG ASSEMBLY
41					4	AN3C37A	BOLT
42					8	D2652	BUSHING
43					4	MS21043-3	NUT
44					4	AN960C10	WASHER

WAS:

ITEM	Qty -411	Qty -412	Qty -441	Qty -443	Qty -011	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-443	WEARSHOE KIT
	1	1			X	D206-648-011	GROUND HANDLING KIT
30	1	1				D2707-043 (OR D2968-043)	TOW RING
31	1	1				AN960JD1016	WASHER
32	1	1				AN970-4	WASHER
33	1	1				MS21042-4	NUT (OR MS21042L4)
34	1	1				AN4-5A	BOLT
35	1	1				AN960JD416	WASHER
36	1	1				D2655	RING
40					2	D2659	GHW LUG
41					4	AN3-37A	BOLT
42					8	D2652	BUSHING
43					4	MS21042-3	NUT (OR MS21042L3)
44					4	AN960DJ10	WASHER

DESIGN	AJS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9421	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	08.10.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

4.3 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skid tubes (D206-642)  
32.12 206 L/L-1/L-3/L-4/407 Low Gear & 407 High Gear Skid tubes (ICA-D206-642)

ITEM	Qty -311	Qty -312	Qty -341	Qty -347	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-311	SKIDTUBE INSTALLATION, LH
		X				D206-642-312	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-341	SKIDTUBE
				X		D206-642-347	WEARSHOE KIT (REPLACES -343)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-11	WEARSHOE (REPLACES D2656-11)	(MODIFY)
22B			1	1		D3536-11	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-35	WEARSHOE (REPLACES D2656-35)	(MODIFY)
24B			1	1		D3536-35	GASKET	(ADD)
26A			54			MS27039-1C08	SCREW	(MODIFY)
26B			54			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-11	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-35	WEARSHOE
26A			54			MS27039-1-08	SCREW
26B			54			AN960JD10L	WASHER

4.4 206L/L-1/L-3/L-4 High Gear Skid tubes (D206-642)  
32.13 206L/L-1/L-3/L-4 High Gear Skid tubes (ICA-D206-642)

ITEM	Qty -411	Qty -412	Qty -441	Qty -447	Qty -013	PART NUMBER	DESCRIPTION
	X					D206-642-411	SKIDTUBE INSTALLATION, LH
		X				D206-642-412	SKIDTUBE INSTALLATION, RH
	1	1	X			D206-642-441	SKIDTUBE
				X		D206-642-447	WEARSHOE KIT (REPLACES -443)
	1	1			X	D206-648-013	GROUND HANDLING KIT

IS:

20A			6			D3537-1	WEARPAD (REPLACES D2648-3)	(MODIFY)
21A			1			D3537-3	WEARPAD (REPLACES D3429-1)	(MODIFY)
22A			1	1		D3535-15	WEARSHOE (REPLACES D2656-15)	(MODIFY)
22B			1	1		D3536-15	GASKET	(ADD)
23A			1	1		D3535-23	WEARSHOE (REPLACES D2656-23)	(MODIFY)
23B			1	1		D3536-23	GASKET	(ADD)
24A			1	1		D3535-37	WEARSHOE (REPLACES D2656-37)	(MODIFY)
24B			1	1		D3536-37	GASKET	(ADD)
26A			60			MS27039-1C08	SCREW	(MODIFY)
26B			60			AN960C10L	WASHER	(MODIFY)

WAS:

20A			6			D2648-3	WEARPAD
21A			1			D3429-1	WEARPAD
22A			1	1		D2656-15	WEARSHOE
23A			1	1		D2656-23	WEARSHOE
24A			1	1		D2656-37	WEARSHOE
26A			60			MS27039-1-08	SCREW
26B			60			AN960JD10L	WASHER

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<del>RF</del>	DRAWING NO.	REV. 3
MFG. APPR.	N/A	DSI 9440	SHEET 3 OF 4
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	WEARSHOE CHANGE	NTS
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QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS3-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET

# NOTES:

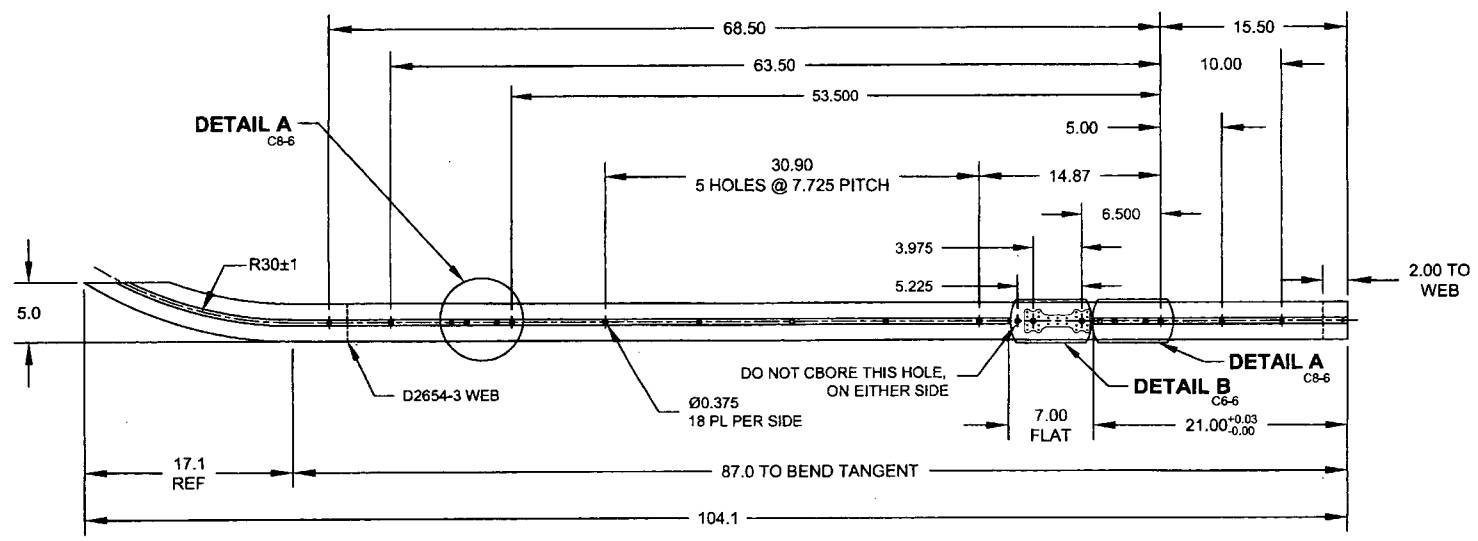
- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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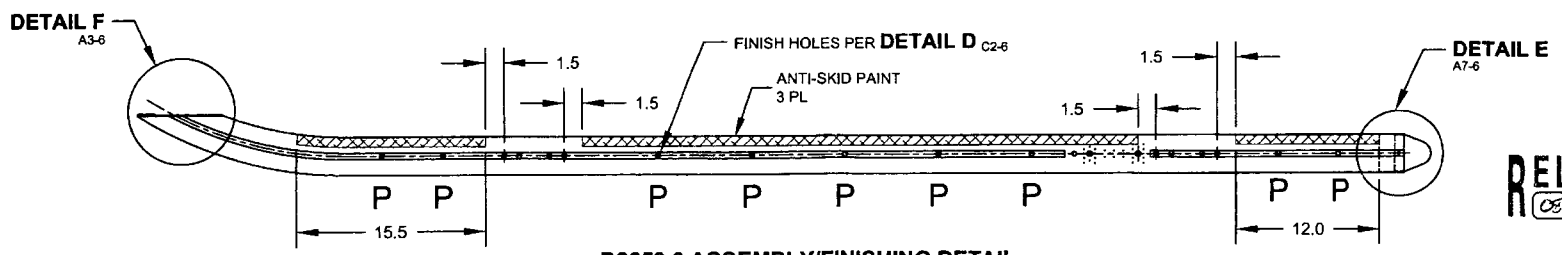
RELEASED  
08-07-23/17







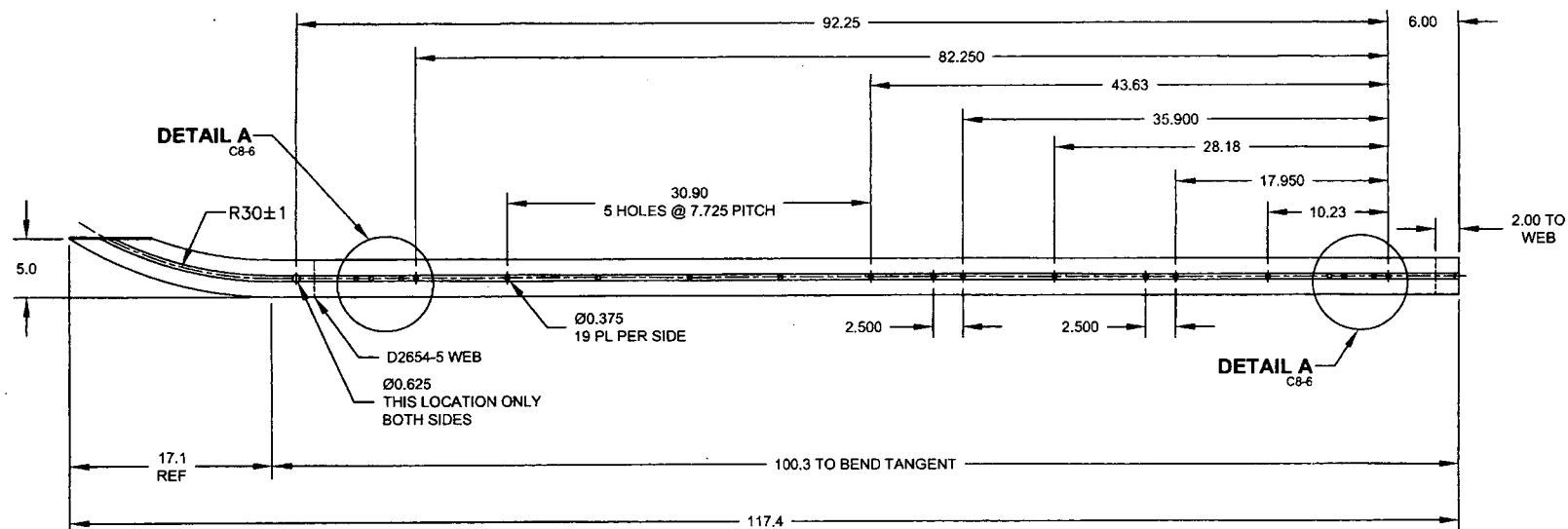
**D2650-3 BENDING/DRILLING DETAIL**



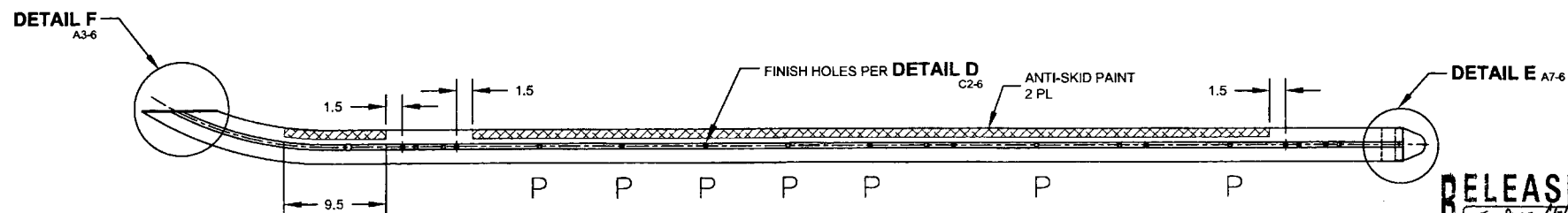
**D2650-3 ASSEMBLY/FINISHING DETAIL**

**RELEASED**  
05 07 22 110

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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**D2650-5 BENDING/DRILLING DETAIL**



**D2650-5 ASSEMBLY/FINISHING DETAIL**

DESIGN	DS	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	B	D2650	SHEET 4 OF 6
APPROVED	AP	TITLE	SCALE
DE APPR.	H	206/407 SKIDTUBE ASSEMBLIES	NTS
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